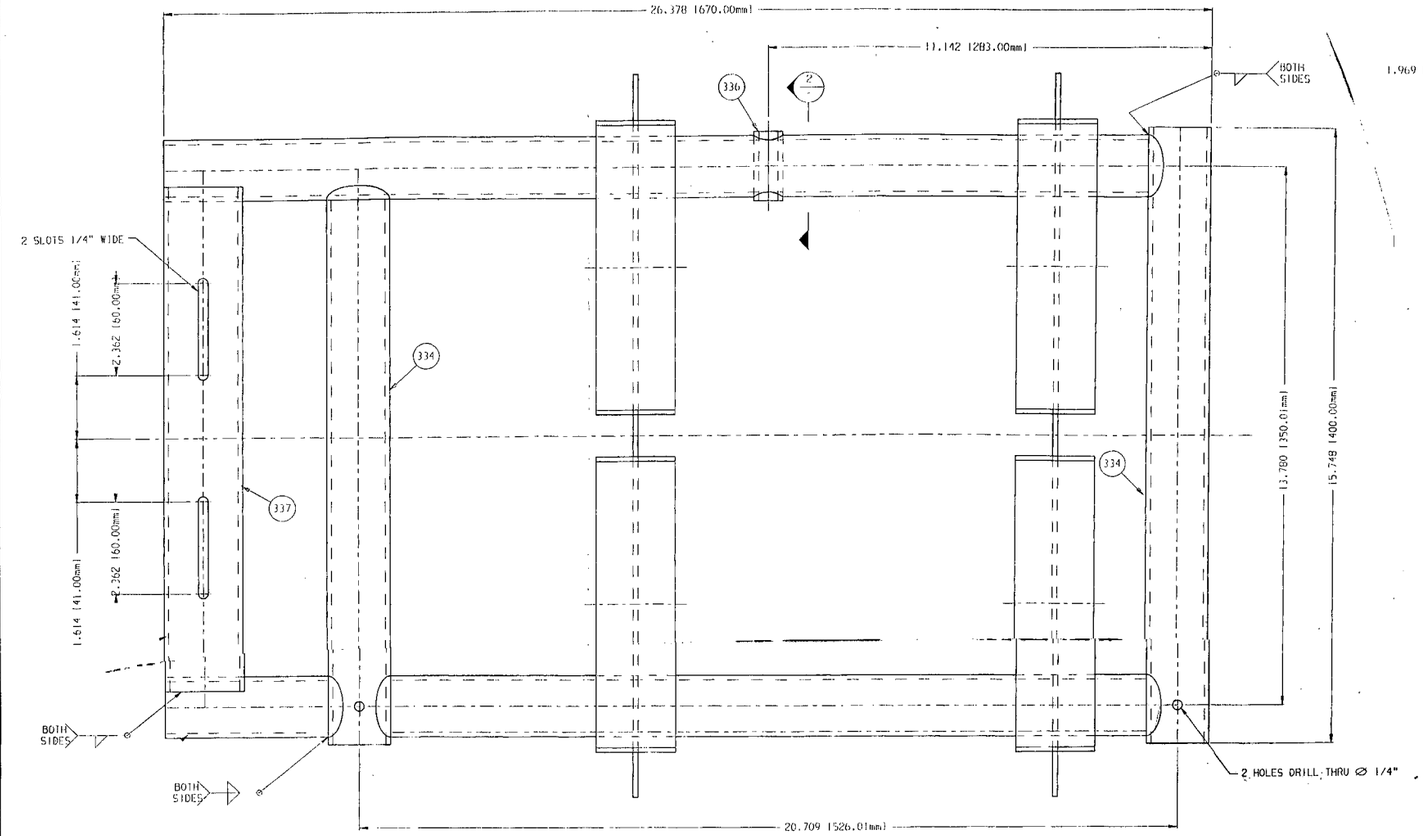
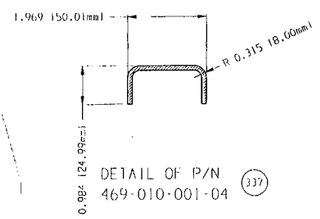
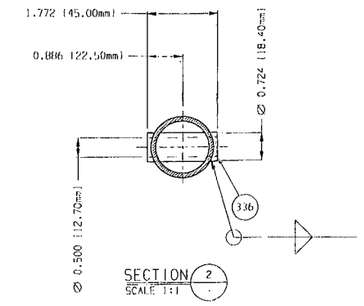




DETAIL OF P/N 469-010-001-04 (337)



SECTION (2) SCALE 1:1

REVISION TABLE			
REV.	DRAWING No.	DATE	DESCRIPTION
A	BHA/DRA/358-06-01	12/11/90	ORIGINAL ISSUE
B	BHA/DRA/358-06-01	.	DWG CHANGES
C	BHA/DRA/358-06-01	19/06/92	BHP EO 1007
D	BHA/DRA/358-06-01	.	BHP EO 1013
E	BHA/DRA/358-06-01	17/06/96	CONSOLIDATION
F	BHA/DRA/358-06-01	15/04/98	ECR-33

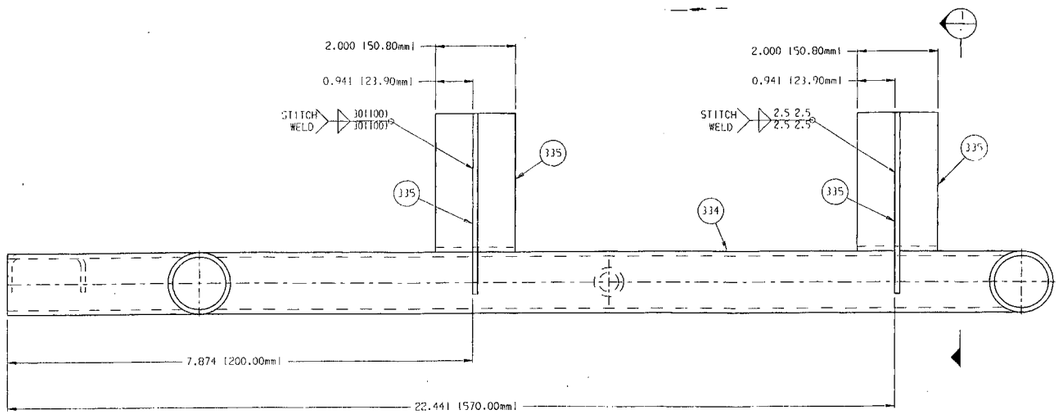
MANUFACTURING NOTES:

1: ALL WELDING IS TO BE TIG PROCESS USING 4043 FILLER WIRE. WELD DISTANCE ARE IN MM.

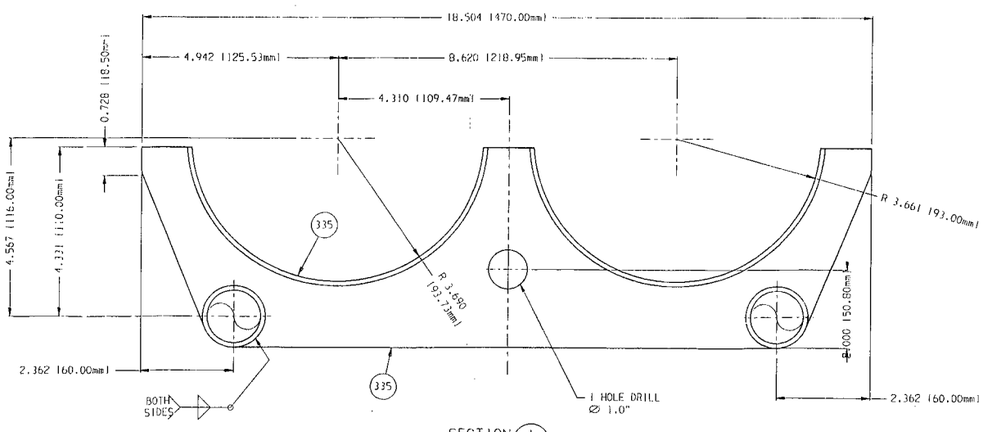
2: PRIOR TO WELDING REMOVE OXIDE COAT WITH STAINLESS STEEL WIRE BRUSH. DEGREASE WITH MEK.

3: COMMERCIAL MATERIAL MUST BE SUPPLIED UNDER COVER OF NATA CERTIFICATE FOR CHEMICAL PROPERTIES AND HARDNESS TO AS1866-1986 FOR EXTRUSION AND AS1734-1986 FOR SHEET PLATE.

4: VISUALLY CHECH FOR FREEDOM FROM CORROSION PITTING, EXTRUSION BILLET AND RUNOUT, EXTRUSION STRAIGHTNESS SHEET AND PLATE FREEDOM FROM KINKS, FREEDOM FROM DENTS AND HEAVY SCRATCHING.



DETAIL OF PART No. 469-010-001 (301)



SECTION (1) SCALE 1:1

APPROVED pursuant to a direction given by Regulation 35 of the Civil Aviation Regulations on date: 15-4-98
signature: C.W.Whitney
name: C.W.WHITNEY
being an Authorised Person for and on behalf of Helitech Pty Ltd Certificate of Approval 3300 A.C.N. 010 600 987

ITEM	QNTY	SHW QUANTITY	PART No.	DESCRIPTION	MATERIAL/ORIGINAL PART NUMBER	SIZE	GRADE	MAT. SPEC.	HEAT TREATMENT	MASS
337	-	2	469-010-001-04	CHANNEL	50.0x25.0x1.0mm ALUM. ALLOY CHANNEL		5005	COMM	H34	
336	-	1	469-010-001-03	BAR	∅ 19.0mm ALUM. ALLOY BAR		6351	COMM	T5	
335	-	2	469-010-001-02	PLATE	1.0mm THICK ALUM. ALLOY PLATE		5005	COMM	H34	
334	-	1	469-010-001-01	TUBE	40.0x3.0mm ALUM. ALLOY TUBE		6060	COMM	T5	
301	-	1	469-010-001	FWD BOTTLE RACK BARE	ASSEMBLY OF ITEMS -1 -->					

REFERENCE DRAWINGS	
BHA/DRA/358-01-01	MATERIALS LIST
BHA/DRA/358-01-02	MATERIALS LIST (CONTINUED)

MANUFACTURING OPERATIONS

ALL DIMENSIONS TO BE MET AFTER PLATING.
REMOVE ALL BURRS.
BREAK ALL SHARP EDGES 0.015"-0.031" 0.4mm-0.8mm

TOLERANCE (Except where otherwise stated)

Over	Up to	Tolerance
0	0.400	0.020
0.4	2.0	0.040
2.0	6.0	0.060
6.0 & OVER		0.080

ANGULAR TOLERANCE U.N.O1 +/- 0.5 DEG

SURFACE ROUGHNESS U.N.O
INCLUDING REAMED HOLES FOR DRILLED HOLES
BEND RADIUS
CORNERS AND FILLETS
MARK PART # IN REGION MARKED:
WELDING
ALL WELDING FULL PENETRATION
A 3mm BEAD MUST REMAIN ON AT LEAST ONE SIDE U.N.O

MATERIAL

MATERIAL

TREATMENT
REFER DWT-ALL-SPM PARAGRAPH 4-5 -> 4.15 FOR SURFACE PREPARATION & PAINTING

DIMENSIONS IN INCHES (mm)

Helitech PTY. LTD.

BRISBANE HELIPORT
LAMINGTON AVE. EAGLEFARM
Incorporated in Queensland

PHONE: (07) 32684077
FAX: (07) 32681815
AS 1100

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DRAWN	NORA KINNUNEN
DATE	15/04/98
SCALE	1:2
CHECKED BY	C.W.WHITNEY
DATE PLOTTED	15/04/98

Client: HELITECH PTY. LTD.

Title: KWIK FLOAT INSTALLATION
FORWARD BOTTLE RACK MANUFACTURE DETAILS
BELL 206 A & B SERIES

IRN	CI	Drawing Number	Revision
331	118	BHA/DRA/358-06-01	F